WINTER Single-side Glue Spreader Maxi Single

WINTER Double-side Glue Spreader Maxi Twin

User Manual

Read this User Manual carefully before use

Keep it in a proper way for future reference

Henrik Winter Holztechnik GmbH
Druckereistr. 8
04159 Leipzig

Tel. +49 (0)341/4619021
Fax. +49 (0)341/4618358
Funk: +49 (0)171/2820443

Email: info@winter-holztechnik.de
Internet: www.henrik-winter.de

H.Winter Holztechnik GmbH

Contents

1 **Safety Instructions** ----------2

1.1 Instructions----------2

1.2 Responsibilities ----------2

1.3 Safety Devices & Precautions----------2

1.4 Safety Warnings & Labeling----------3

1.5 Nameplate----------4

2 Specification----------5

2.1 Purpose and Applications----------5

2.2 Main Technical Parameters----------5

2.3 Structure of Machine----------6

2.4 Overall Dimension ----------7

3 Operating Environment, Lifting and Installation ----------7

3.1 Operating Environment----------7

3.2 Lifting ----------8

3.3 Installation ----------8

3.4 Storage----------9

4 Operation of Machine----------9

4.1 Operating Position----------9

4.2 Parts Description----------10

4.3 Installation & Adjustment ----------12

4.4 Operation of Machine----------13

5 Maintenance of Machine----------13

6 Electric Safety----------14

6.1 Safety Guidelines for Electric System ----------14

6.2 Electric Schematic Diagram----------17

7 Common Failures & Shooting Methods----------19

8 Fragile Parts----------19

9 Packing List----------20

10 Factory Address----------21

H.Winter Holztechnik GmbH

1 Safety Instructions

1.1 Instructions

All people related to the use of this tooling machine should have a careful reading of this User Manual so as to learn the operation procedures, safe operation knowledge and maintenance of this machine specified in this Manual. You should also place this Manual near to this machine for your convenience.

The copyright of this User Manual is reserved by Weideli, and this Manual is only provided for use by the purchaser and its employees. All content specified in this Manual shall not be copied, duplicated, handed out or transferred in any way. Otherwise, we will claim against such person as breaks these principles.

1.2 Responsibilities

The regulations and conditions in relation to the use of this tooling machine is strictly binding, and we shall not be responsible for any personal injury or loss of properties caused by one or more of the following reasons:

(1). Failure to observe the regulations and provisions specified in this Manual for transportation, installation, commissioning, operation, warning and maintenance of this machine;
(2). Operation of a tooling machine with any safety hazard or faulty device;
(3). Improper installation or forcible removal of safety protection devices;
(4). Processing of workpiece exceeds the designed capacity of this machine or the cutters and spare parts used are out of the designed range of this machine.
(5). No reliable earthing device installed for this machine;
(6). Unauthorized change over the structure and control of this machine, such as the change of specification, running speed and control method.
(7). Forcible disassembly or replacement of spare parts without obtaining the knowledge about the structure and control method of this machine;
(8). Safety precautions not well conducted when checking, maintaining and repairing this machine;
(9). Insufficient monitoring over the wearing of parts and disasters brought by Act of God.

1．3 Safety Devices & Precautions

（1）All safety devices must be installed properly before use of this machine in order to ensure a safe operation;
（2）Disassembly of the safety devices is only allowed when the power supply of the this machine is turned off;
（3）Operators should fully understand all safety guidelines and danger warnings specified in the markings;
（4）Please operate this machine only when all safety devices are under normal working conditions;
（5）Make sure that nobody will be injured because of the starting of this machine before startup.
（6）Sufficient attention should be drawn to any minor error or failure, and regular check and inspection should be conducted at least once for this machine.

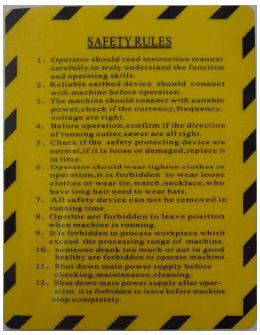
H.Winter Holztechnik GmbH

（7） Transportation, installation, commissioning and maintenance of this machine should be only done by the professional staffs.

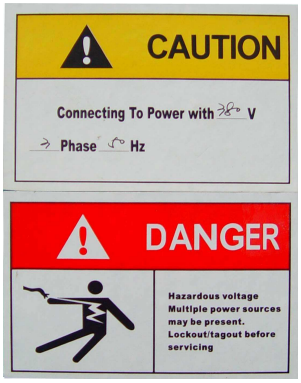
（8）Installation and checking for electric system of this tooling machine shall be conducted by those electric technicians who have related knowledge and experience and the background in mechanical driving field.

（9）Check the electric equipment regularly and handle all loose or damaged electric parts in time. No checking or maintenance is allowed to be done when the machine is live. When checking or maintenance, the main switch shall be shut down and leave a man to watch over it.

1.4 Safety Warnings & Labeling


SAFETY RULES
1. Operator should read instruction manual carefully,to truly understand the function and operating skills.
2. Reliable earthed device should connect with machine before operation.
3. The machine should connect with suitable power,check if the currency,frequency, voltage are right.
4. Before operation,confirm if the direction of running cutter,sawer are all right.
5. Check if the safety protecting device are normal,if it is loose or demaged,replace it in time.
6. Operator should wear tighten clothes in operation,it is forbidden to wear loose clothes or wear tie,watch,necklace,who have long hair need to wear hats.
7. All safety device can not be removed in running time.
8. Opertor are forbidden to leave position when machine is running.
9. It is forbidden to process workpiece which exceed the processing range of machine.
10. someone drank too much or not in good healthy are forbidden to operate machine.
11. Shut down main power supply before checking,maintenance,cleaning.
12. Shut down main power supply after operation, it is forbidden to leave before machine stop completely.

Warning in this label requires the operator to strictly observe the specifications. Any carelessness may lead to body injury.



The label indicates the correct power with applicable voltage, current and frequency. Any carelessness may lead to a damaged machine or fire.

This mark indicates that the running direction of the main shaft must be correct, otherwise it may lead to body injury.

This label tells you not to touch this part when power on, otherwise it may lead to electric shock

This label is for earthing direction indicating that this machine must be grounded and preserved the earthing line here. Avoidance of this step may lead to electric shock or that the machine is burnt down.

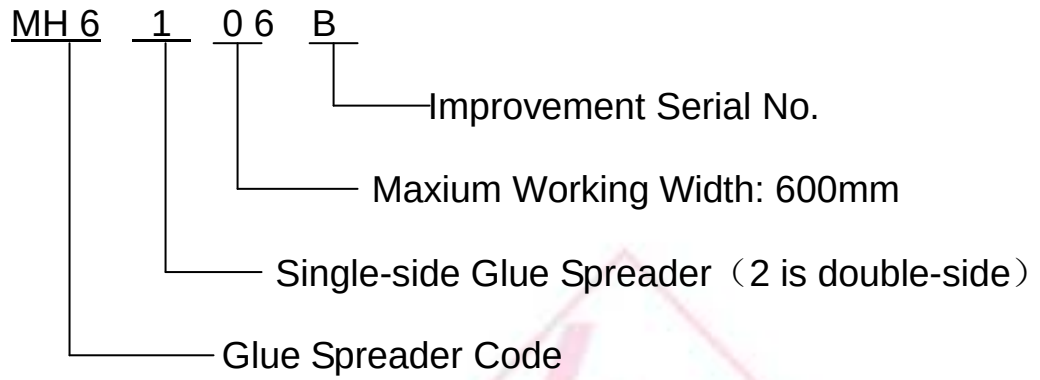
This label is used to warn you not to open the protective cover when the machine is running; otherwise it may lead to your hand injury.

H.Winter Holztechnik GmbH

1.5 Nameplate

Check the model number, serial number and production date to confirm whether they are in compliance with the purchase contract and check whether the machine is damaged or not or whether any part is lost or not.

(1) Model Number


MH 6 1 0 6 B
Improvement Serial No.
Maxium Working Width: 600mm
Single-side Glue Spreader（2 is double-side）
Glue Spreader Code

(2) Nameplate of Glue Spreader, See Figure 1-1

Figure1-1 Nameplate

2 Specification

2.1 Applicable Range and Features

This machine is mainly used for spreading UR glue, PERNOL-RESORCIONOL glue and PVAC glue and EPI glue by rolling, applicable to the pre-gluing of plywood.

★ This machine is made with detachable AL-alloy framework allowing it beautiful in design and convenient

★ Each roller is driven by a motor separately providing more reasonable power.

★ Roller positions are preserved for users to install backup rollers, enabling it to be a double-side glue spreader.

★ Copper glue stopper is adopted to prevent the glue from leaking

★ Synchro-lifting mechanism is used to satisfy the requirements for processing different thickness of boards.

★ Wheels installed under the seat to make the machine movable freely.

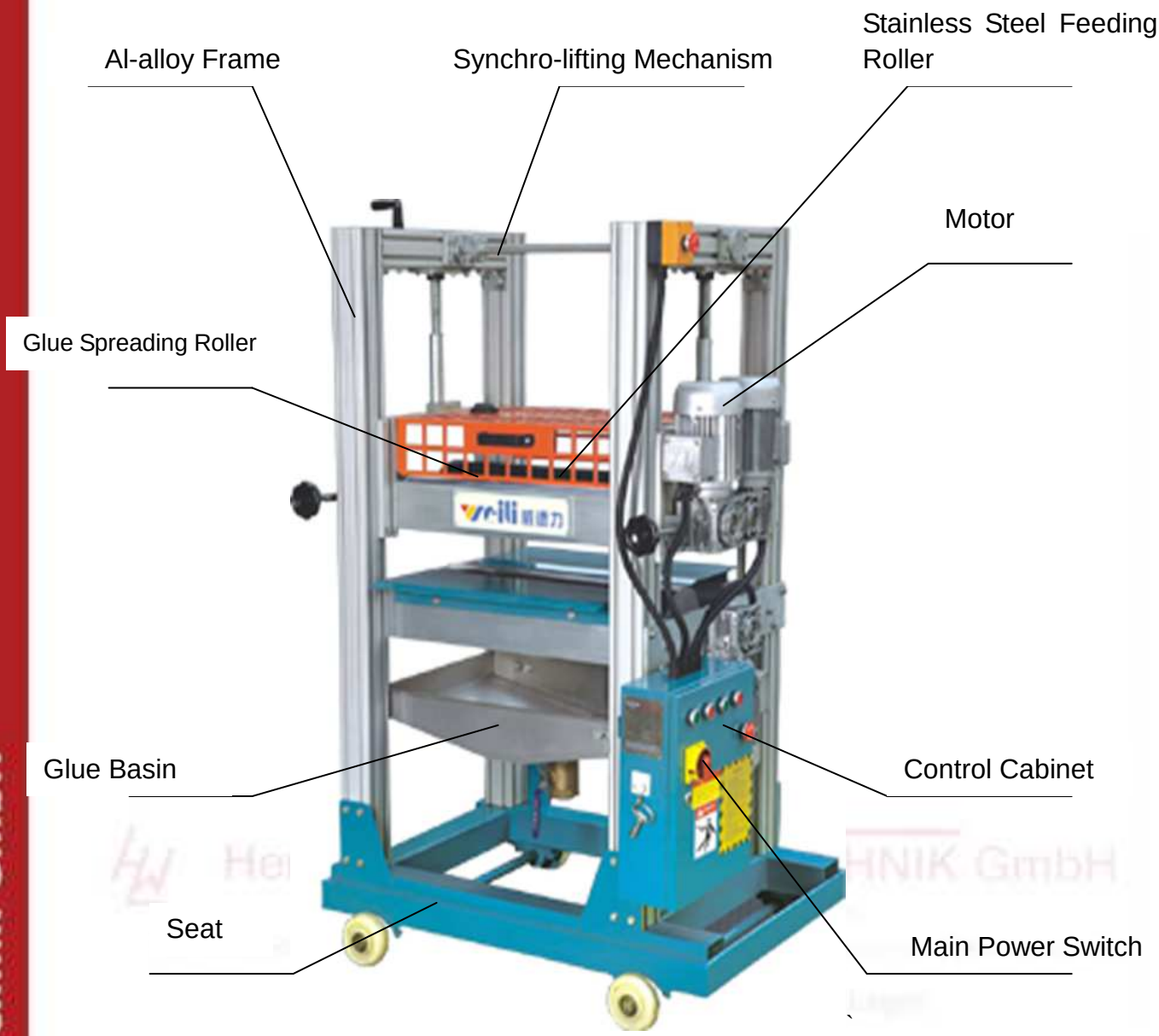
H.Winter Holztechnik GmbH

2.2 Main Technical Parameters

model	MH6106B	MH6206B
Max. Working Width	600 ㎜	600 ㎜
Max. Thickness of Workpiece	100 ㎜	100 ㎜
Feeding Speed	22m/min	22m/min
Power	0.37kw×3	0.37kw×4
Overall Dimension	1100×810×1650 ㎜	1100×860×1650 ㎜
Weight	450 ㎏	450 ㎏

H.Winter Holztechnik GmbH

2.3 Structure of Machine



H.Winter Holztechnik GmbH

2.4 Overall Dimension See Figure 2-1(MH6106B)

Figure 2-1 Overall Dimension

3 Operating Environment, Lifting, Installation and Storage

3.1 Operating Environment, See Figure 3—1

Figure 3—1 Operating Environment

Ambient Temperature	0--45°
Ambient Humidity	Less than 90%RH
Environment	No corrosive or inflammable gas or oil mist indoor

Elevation	Less than 1000m

3.2 Lifting

This machine can be shipped partially or wholly. Generally, it is shipped wholly. During the transportation, please take necessary measures to protect the machine from sunshine and rainfall. When unloading, professional workers are required to unload this machine.

(1) During loading and unloading, effective safety protection devices should be in place and no people is allowed to stay around the site except related workers.

(2) Use the capable crane or fork lift and make sure that the machine can remain stable during the process.

(3) After unloading, remove all tools and safety devices in time.

3.3 Installation

3.3.1 Placement of Machine

This tooling machine needs to be placed on the hard cement ground which should be flat and smooth enough. Sufficient space should be preserved around the machine. Level calibration should be done vertically and horizontally for this machine. The calibrated value shall not be more than 0.5 ㎜.

3.3.2 Requirements for Power Supply

The required power supply is: 3-phase AC power, voltage: 380V～400V and frequency: 50Hz.

3.3.3 External Power Connection

(1) Power Distribution

According to the requirements for power supply specified in the switchgear cabinet, Connect the power supply with same voltage, current and frequency at Position C on the incoming wire box.

(2) Running Direction of Motor

The right running direction of motor is: left motor runs counterclockwise and the right motor runs clockwise (see from top to bottom).

3.3.4 Wiring

(1) Before wiring, first make sure that the power supply required for the machine is same with the power supply provided by your factory.

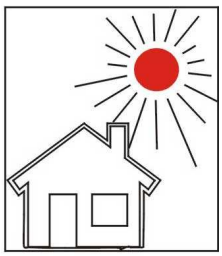
(2) the external power lines should go through the automatic load switch before connecting with this tooling machine, and then connect the power lines with L1, L3, L3 and PE.

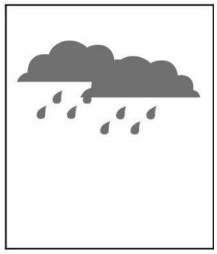
(3) This machine should be properly grounded.

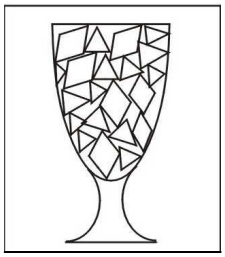
H.Winter Holztechnik GmbH

3.4 Storage:

In order to prolong the service life the tooling machine, please avoid the following:


Long-time Direct Sunshine


Stored at a humid place


Violent Vibration

Unauthorized Approaching

4. Operation of Machine

4.1Operating Position Fig 4-1

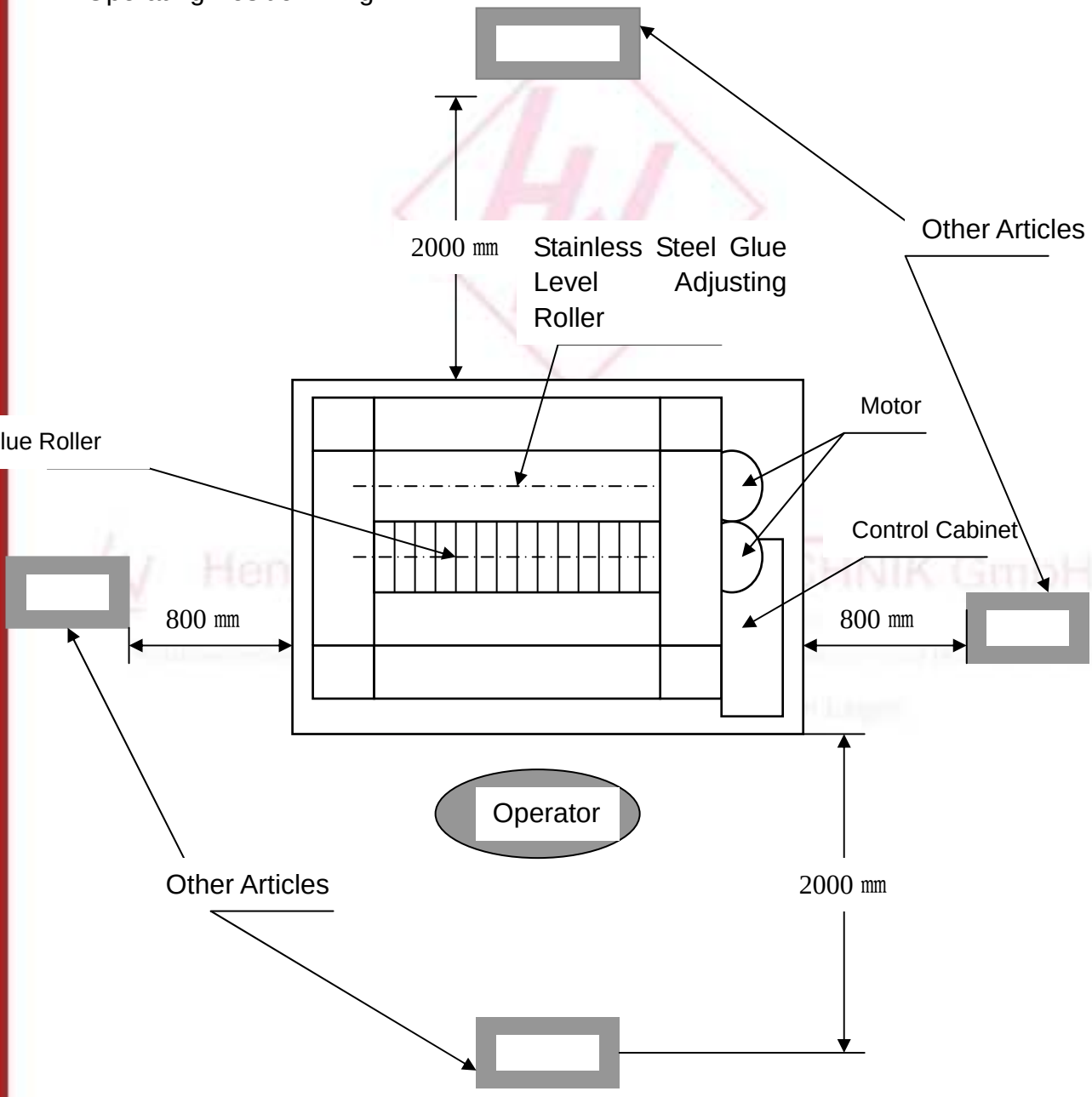


Fig 4-1 Operating Position Figure

4.2 Parts Description

（1） Buttons on Control Cabinet

Main Power Switch: before use, this switch should be turned on to “1” indicating the power is on, and when turned to “0”, it indicates the power is shut down.

Emergency Stop Button: In the event that any accident or failure occurs when the machine is running, press down this button and the machine will stop immediately Before starting, this button must be at “Reset” position.

Glue Roller Start Button: Once the main power switch is turn on, press down this button to start the glue roller.

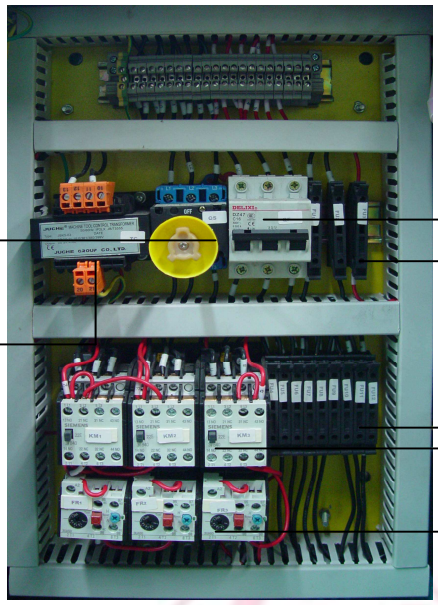
Glue Roller Start Button: Once the main power switch is turn on, press down this button and the glue roller will stop working.

Glue Spreading Roller Start Button: Once the main power switch is turn on, press down this button, and the glue spreading roller will start working.

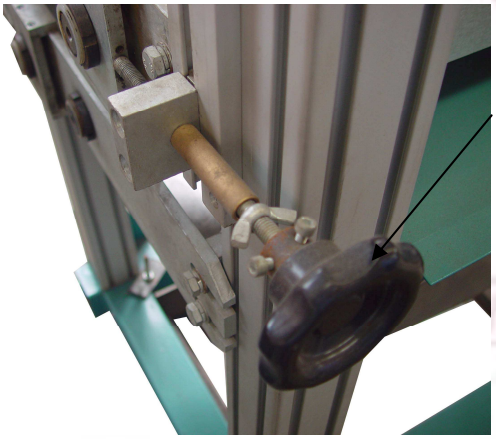
Glue Spreading Roller Start Button: Once the main power switch is turn on, press down this button, and the glue spreading roller will stop working.

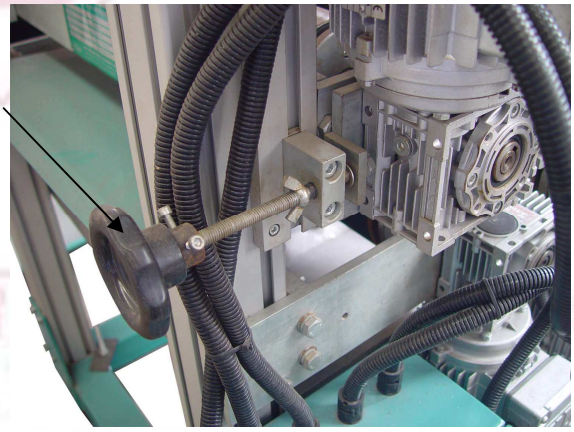
H.Winter Holztechnik GmbH

（2）Electric Control Cabinet



(3) Glue Level Adjusting Device





By adjusting the hand wheel show as the Figure above, precision and even spreading effect will be obtained. This device is used to adjust the distance between glue spreading rollers. When spreading glue, the spreading rollers should keep touch with the mixer.

Note: The glue spreading roller can't be adjusted to be too close to the glue level adjusting roller; otherwise the heat produced by friction may lead to temperature increase of the spreading roller or make the motor damaged because of overload.

H.Winter Holztechnik GmbH

(4) Synchro-lifting Adjusting Device

By adjusting the handle shown in the left picture, you can adjust the distance between the upper glue roller and the lower roller. When processing workpieces with different thickness, you can get the precision distance by adjusting this handle.

4.3 Installation and Commissioning

（1）Installation

Place this machine on the flat and hard ground and use a gradienter to adjust the level of machine, and then connect the machine housing with the earthing, and finally connect with the power same with the power required for this machine with applicable voltage, current and frequency.

（2）Running Direction of Glue Roller

Glue Spreading Roller Glue Level Adjusting Roller

First start the machine to observe whether the running direction is correct. The right direction is shown as the figure.

If the direction is wrong, exchange the position of any two power lines of L1, l2 and L3.

（3）Adjustment of Workpiece Thickness

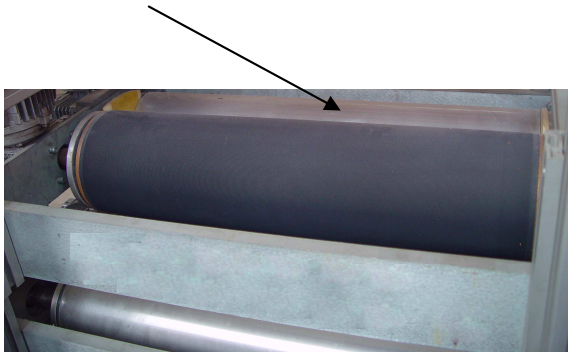
There is a gauge opposite to the left side of the machine. When the pointer is at “0” position, the upper glue roller is just attached with the lower glue roller. You can make adjustment at that time according to the thickness of the machine. If the thickness is “10mm” turn the pointer clockwise to “9mm”. (Note: In order to protect the glue roller from being worn out, the distance between two rollers can’t less than the thickness of the workpiece too much, generally 0.5-1.5mm is better. When spreading glue, the workpiece should be applied at full length, otherwise the roller will not work evenly which may result in the glue roller worn out

H.Winter Holztechnik GmbH

and uneven spreading.

（4）Glue Filling

Before fill the glue into the glue roller, please first adjust the glue level wheel to allow a suitable distance between the glue roller and the upper rolling stick, and then fill glue at the place where the black arrow points (Right Figure). (Note: before filling glue, it is not allowed to start the machine when the glue roller is tightly close with the rolling stick, otherwise it will damage the surface of the glue roller).



（5）Adjustment of Glue Level

By adjusting the left and right adjusting hand wheel to adjust the thickness and evenness of glue. The two wheels can't be interactive. You need to adjust them respectively. You can stop adjusting until the glue becomes even.

4.4 Operation of Machine

（1） Before starting, make sure that nobody is touching the rollers or any other moving parts.

（2） Check each part is at right place and all safety devices are well fastened.

（3） Turn the main power switch to "O" position and press down the two green start buttons;

（4） Adjust the distance between the glue roller and the upper rolling stick until they get close with each other enough;

（5） Fill the glue. When filling, be careful for your safety. Your body can't touch the glue rollers.

（6） After the glue is filled, adjust the synchro-lifting handle and glue level adjusting wheel according to the thickness of the workpiece so as to apply the glue evenly on the workpiece.

（7） Press down the red stop button to stop the machine and turn the main power switch to"1" position.

（Note: complete cleaning should be done before the machine is shut down）

H.Winter Holztechnik GmbH

5 Maintenance

5.1Daily Maintenance:

（1）Keep the machine clean, and all driving parts and contacts should be well lubricated.

（2）Do not place any other things on the machine;

（3）As the glue will become hard which may seriously damage the glue roller, you must clean off the glue in the glue basin, glue rollers and the glue level adjusting roller using water if the machine stops for over 15 minutes.

5.2 Cleaning:

（1）In order to keep the machine in good conditions, it is necessary to clean the machine.

（2）When cleaning, it is possible to hurt people, so pay attention to the safety.

（3）Please try to use up all glue in the machine. When cleaning, please add 30℃ water to mix with the glue, and then open the clearance between the glue roller and other rollers to clean off the glue.

（4）Narrow the clearance between the glue roller and the two rolling sticks to the normal position , and then add warm water with the maximum temperature of 30℃ and mix with the remaining glue. Open the clearance between the glue roller and the glue level adjusting roller to discharge the water.

（5）Shut down the machine and turn the main power switch to “ON” position.

（6）Take down the two copper glue stoppers on both sides and clean them and the bearing with the warm water.

（7）If the surface and groove of the glue roller need to be cleaned, first take down the glue roller, and clean it using long-handle brush and warm water (Note: do not use any sharp or hard tools, dirty cloth or cotton waste for cleaning. Before assembly, clean the shaft and bearing first.).

5.3 In-process Maintenance:

（1） Operate this machine with the correct method. It is not allowed that the pressing is our of the designed capacity of this machine.

（2） No maintenance is allowed to be conducted when working. When the machine is running, the operator should not leave away until the machine is shut down as required.

（3） Before repairing and replacing the spare parts or assembly and reassembly of motor, the power should be shut down.

H.Winter Holztechnik GmbH

5.4 Periodic Maintenance:

（1） Before each processing, first check the driving parts and safety devices are properly installed, and run this machine without putting on the workpieces to check whether its action is correct, flexible and reliable.

（2）、Overall check should be made once per month focusing on the elements in the switchgear cabinet, overtravel limit stop and pull-string emergency stop as well as whether the driving parts are well lubricated and whether the safety protection devices are well fixed. If necessary, adjust or replace such devices.

5.5. Storage Maintenance

（1） If you do not use this machine, please clean it and apply lubricating oil to all driving parts and pack it properly.

（2） This machine should be stored at a dry and well-ventilated room to avoid the direct sunshine and rainfall.

（3） Selection of Lubricant for Electric Sliding Track: Calcium-based Lubricant.

or：Caltex：Meropa68 Lubricant Caltex：Multifak Ep2 Lubricant

6 Electric Safety

6.1 Safety Guidelines for Electric System

（1）Only well-trained professional persons with professional knowledge are allowed to conduct the electric repairing or remove troubles.

（2）Do not modify or ignore the protection devices;

（3）Before starting, have a careful reading of the User Manual and warnings.

（4）When the failure is confirmed, do remember to shut down the power and the main switch should be locked.

（5）Be aware of the humid area to prevent the electric shock

（6）Before the electric power is distributed to any equipment, any person should be clean and

（7）Do not open the switchgear cabinet except that it is necessary to check the electric equipment.

（8）Do not change the circuit unless authorized by the qualified manufacturer

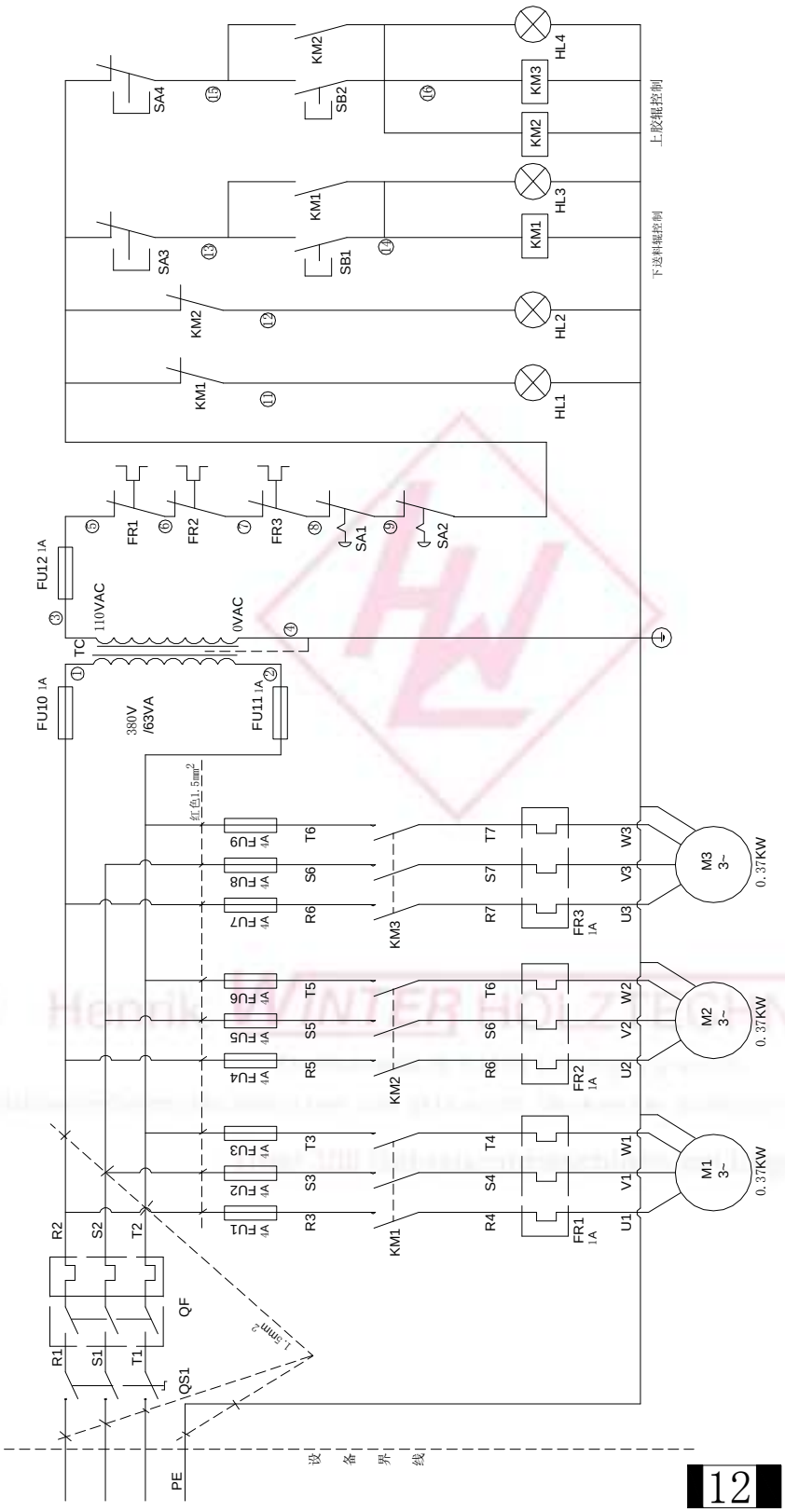
（9）When replacing the electric parts, first confirm the new parts are in compliance with the specification, including the color code on the power cable.

（10）When operating the electric equipment, do not wear any metal glasses, necklace, ring, watch or bracelet, etc.

H.Winter Holztechnik GmbH

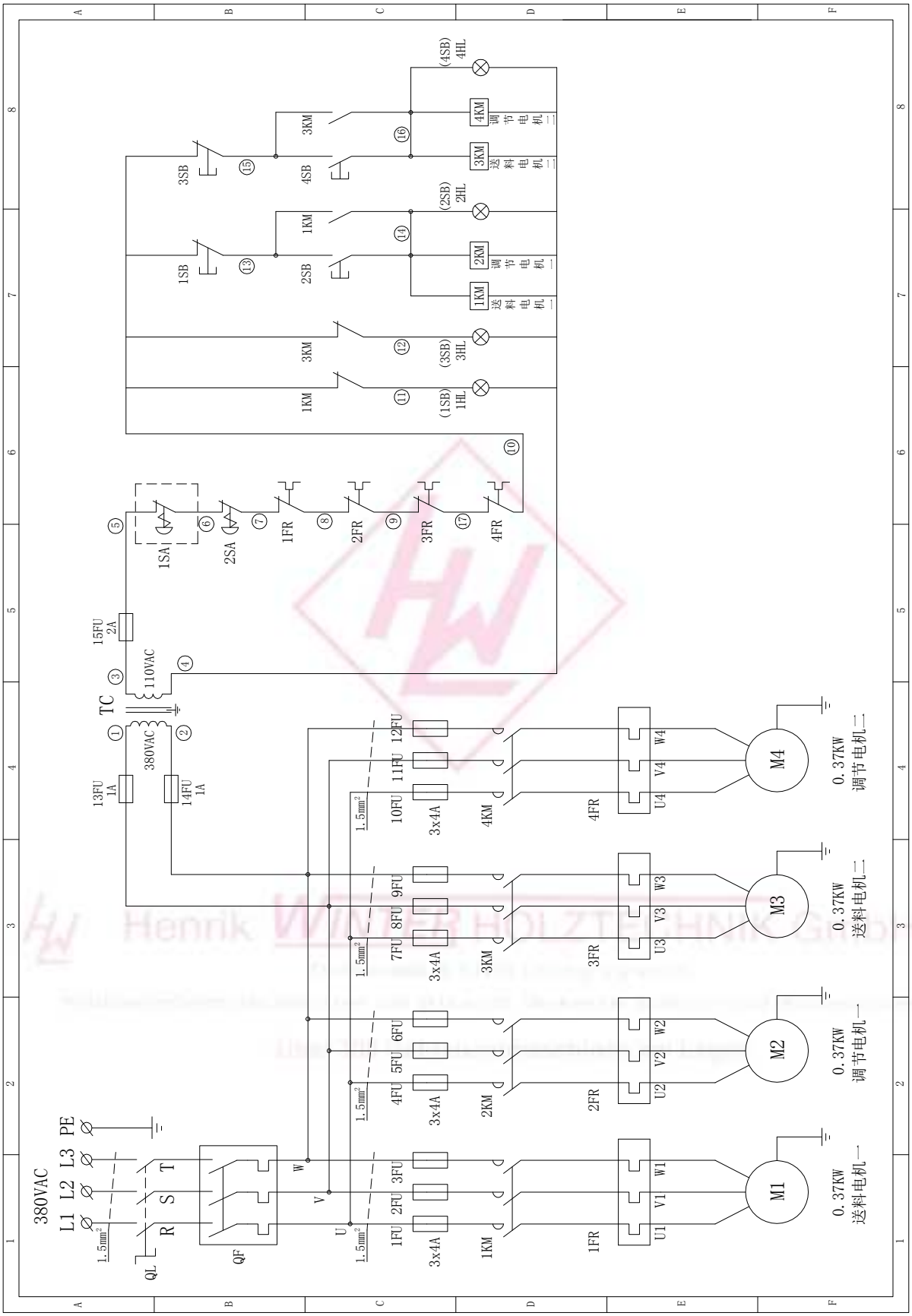
6.2 Electric Schematic Diagram

（MH6106B）



12

(MH6206B)


380VAC
L1 L2 L3 PE
R S T
QL
QF
U V W
1.5mm²
1FU 2FU 3FU
4FU 5FU 6FU
7FU 8FU 9FU
10FU 11FU 12FU
3x4A
1KM 2KM 3KM 4KM
1FR 2FR 3FR 4FR
U1 V1 W1
U2 V2 W2
U3 V3 W3
U4 V4 W4
M1 M2 M3 M4
0.37KW
送料电机一
调节电机一
送料电机二
调节电机二
13FU 1A
14FU 1A
380VAC
TC
110VAC
15FU 2A
1SA 2SA
1FR 2FR 3FR 4FR
1SB 2SB 3SB 4SB
1KM 2KM 3KM 4KM
(1SB) 1HL
(2SB) 2HL
(3SB) 3HL
(4SB) 4HL
送料电机一
调节电机一
送料电机二
调节电机二

7. Failures and Troubleshooting Methods

If the following failures are found when checking, you may refer to the troubleshooting methods given below for preliminary treatment. If failure still exists after doing so, please consult with the manufacturer for technical support.

Failure	Reasons	Killing Methods
When power on, the motor unable to start	Open phase of power or short circuit	Check and correct
	Damaged control AC contactor or the thermal relay in open circuit	Check the AC contactor and thermal relay
	Fuse burnt	Check and replace t he fuse
Uneven spreading both in the left and right sides of the workpiece	The left and right adjusting wheels are not well adjusted	Adjust the two wheels in consistence
No matter how to adjust, the glue can not spread evenly	Glue roller damaged	Replace the glue roller

8 Fragile Parts

S/N	Name	Quantity
1	Glue Spreading Roller	1
2	Glue Level Adjusting Roller	1
3	Glue Stopper	1
4	Bearing	2

9. Packing List

Packing List

Weideli Woodworking Machinery Industrial Co., Ltd.		Model No.	
		MH6106B	
S/N	Name & Specification	Quantity	Remarks
1	Main Machine	1	
2	User Manual	1	
3	Certificate of Compliance	1	
4	Warranty Card	1	

Checker: Date:

H.Winter Holztechnik GmbH